Listing of Claims:

1. (Currently amended): A method of forming a catalytic converter, the method comprising:

providing a catalytic converter having a central portion and an end portion, wherein the central portion defines a horizontal central axis;

rotating the catalytic converter around the central axis;

placing a roller perpendicular to the central axis;

keeping the roller perpendicular to the central axis;

~~and~~ forming the end portion by moving the roller in a transverse direction with respect to the central axis; and

forming the end portion by moving the roller in a parallel direction with respect to the central axis.

2. (Cancelled)

3. (Original): The method of claim 1, wherein the end portion defines an axis at an angle with respect to the central axis of the catalytic converter.

4. (Original): The method of claim 3, wherein the angle between the axis of the end portion and the central axis is in the range of 30° to 60°.

5. (Original): The method of claim 1, wherein moving the roller in a transverse direction with respect to the central comprises:

dividing the end portion into multiple imaginary planes perpendicular to the central axis;

forming a contour corresponding to the multiple imaginary planes; and

programming the roller to follow the contour.

6. (Original): The method of claim 1, further comprising rotating the roller around an axis parallel to the central axis.

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7. (Original): The method of claim 1, wherein the step of placing the roller comprises the step of contacting a surface of the catalytic converter such that moving the roller in the transverse direction reduces the diameter of the catalytic converter at the surface.

8. (Original): The method of claim 1, wherein forming the end portion further comprises cutting an end part of the end portion such that the end part is angled with respect to a vertical axis of the catalytic converter.

9. (Currently amended): A method of forming an end portion of a catalytic converter, the method comprising:

providing a catalytic converter having a central portion and an end portion such that the central portion defines a horizontal central axis;

rotating the catalytic converter around the central axis;

placing a roller perpendicular to the central axis;

keeping the roller perpendicular to the central axis; ~~and~~

moving the roller in a transverse direction with respect to the central axis, wherein the end portion defines an axis at an angle with respect to the central axis; and

moving the roller in a parallel direction with respect to the central axis.

10. (Cancelled)

11. (Original): The method of claim 9, wherein the angle between the axis of the end portion and the central axis is in the range of 30° to 60°.

12. (Original): The method of claim 9, wherein moving the roller in a transverse direction with respect to the central comprises:

dividing the end portion into multiple imaginary planes perpendicular to the central axis;

forming a contour corresponding to the multiple imaginary planes; and

programming the roller to follow the contour.

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13. (Original): The method of claim 9, rotating the roller around an axis perpendicular to the central axis.

14. (Original): The method of claim 9, wherein the step of placing the roller comprises contacting a surface of the catalytic converter such that moving the roller in the transverse direction reduces the diameter of the catalytic converter at the surface.

15. (Original): The method of claim 9, wherein forming the end portion further comprises cutting an end part of said end portion such that the end part is angled with respect to a vertical axis of the catalytic converter.

16. (Currently Amended): A method of forming an oblique end portion of a catalytic converter, the method comprising:

providing a catalytic converter having a central portion and an end portion such that the central portion defines a horizontal central axis;

rotating the catalytic converter around the central axis;

placing one roller perpendicular to the central axis such that the roller contacts a surface of the end portion;

keeping the roller perpendicular to the central axis;

~~moving the roller in a transverse direction with respect to the central axis;~~

moving the roller in a transverse direction with respect to the central axis and moving the roller in a parallel direction with respect to the central axis, such that the end portion defines an axis at an angle with respect to the central axis; and

reducing the diameter of the end portion in the surface .

17. (Original): The method of Claim 16, wherein the angle between the axis of the end portion and the central axis is in the range of 30° to 60°.

18. (Original): The method of Claim 16, wherein moving the at least one roller in a transverse direction with respect to the central comprises:

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dividing the end portion into multiple imaginary planes perpendicular to the central axis;

forming a contour corresponding to the multiple imaginary planes; and

programming the roller to follow the contour.

19. (Original): The method of claim 16, rotating the roller around an axis perpendicular to the central axis.

20. (Original): The method of claim 16, wherein forming the end portion further comprises cutting an end part of the end portion such that the end part is angled with respect to a vertical axis of the catalytic converter.

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